

Work Order ID 120673

120673

Page 1

June-10-14 10:11:36 AM

Item ID: D3910-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Lug
 Start Date: 6/10/14 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 6/20/14 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	E								
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to Metec : <u>24538</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.00							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control									

CY 14106110 60

P 14/6/20 (60)

DAS
27
9-89
4/6/20

60
60

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June-10-14 10:11:36 AM

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Required Date: 6/20/14 Req'd Qty: 60.00 *60* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						60	7/16/14-23		
Hand Finish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						60	14-6-24		DAS 34 9.89
QC	Memo	0.00							
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160						60	14-6-24		DAS 34 9.89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:05. OVEN TEMPERATURE: 320 FINISH TIME: 11:35.								

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120673

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Item ID: D3910-7 Accept ***N900040100*** Setup Start ***NS1***
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID DAS	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00	27						
170			9-89						
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>51523</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

(60)
Count

60X DAS 28 9-89 JUN 26 2014

MLJ 14-06-26

14-6-26

Picklist Print

Page 1

June-10-14 10:11:36 AM

Work Order ID: 120673

120673

Parent Item: D3910-7

D3910-7

Parent Item Name: Crosstube Lug

Start Date: 6/10/14

Required Date: 6/20/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 14.05.21 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No				f	415.7828		8			
-------	--	--------------	----	--	--	--	---	----------	--	---	--	--	--

D2423

Lug Extrusion

CZ14/06/10

Location

Loc Qty

Loc Code

HALL

415.782848

~~105422~~

~~49.666848~~

115529

366.116

D3910-7P

Purchased

No

Each

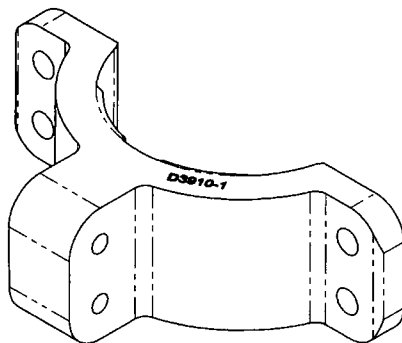
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60

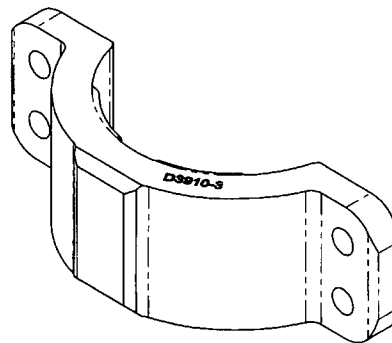
D3910-7P

Crosstube Lug

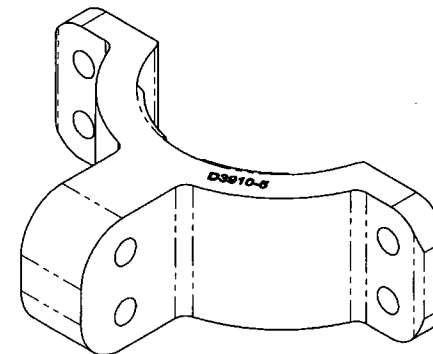
P44/4/20 (60)



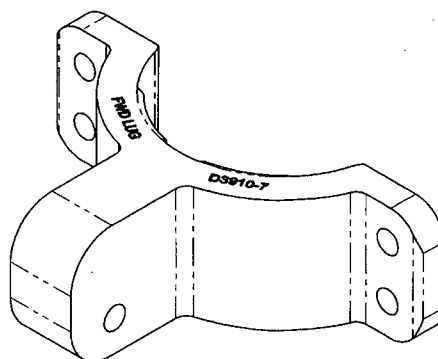
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005

RELEASED

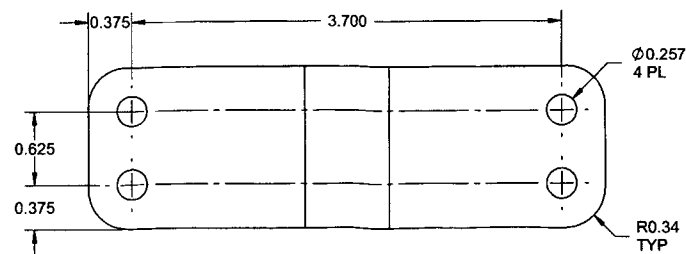
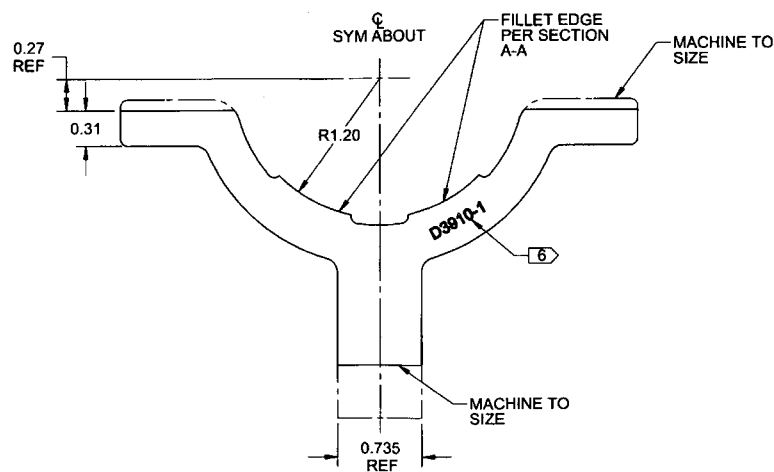
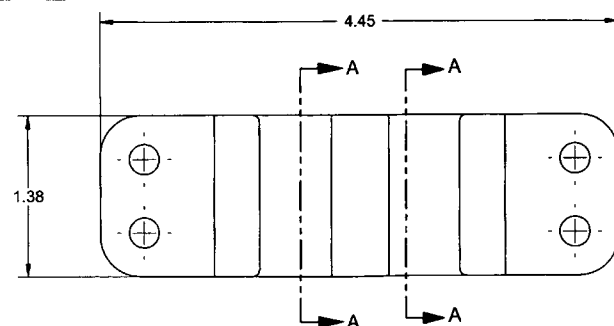
2014 JUN 05 *CP*
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

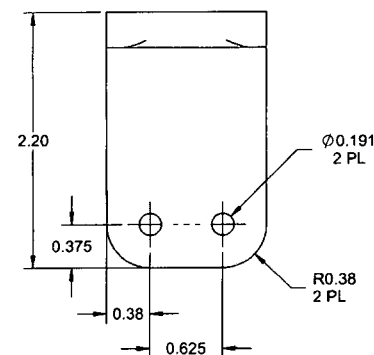


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG



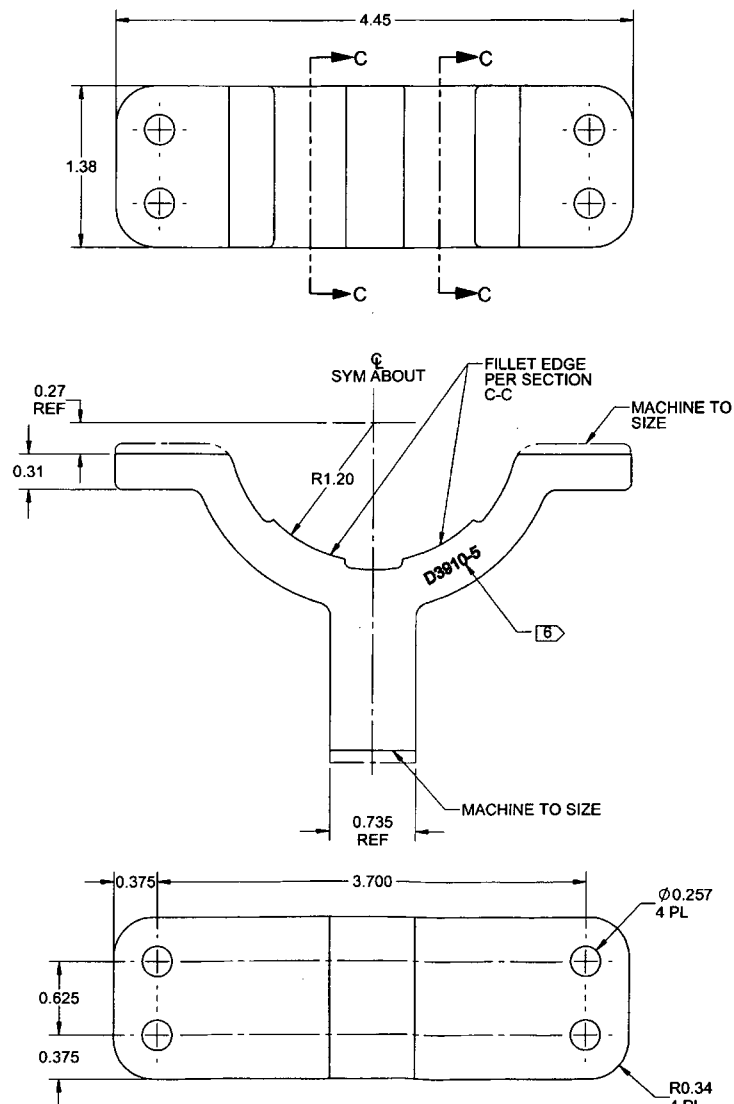
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2014 JUN 05

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MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 5
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SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG

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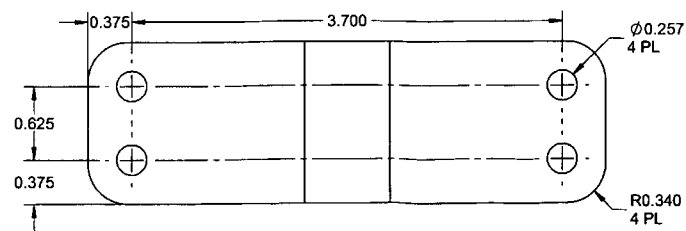
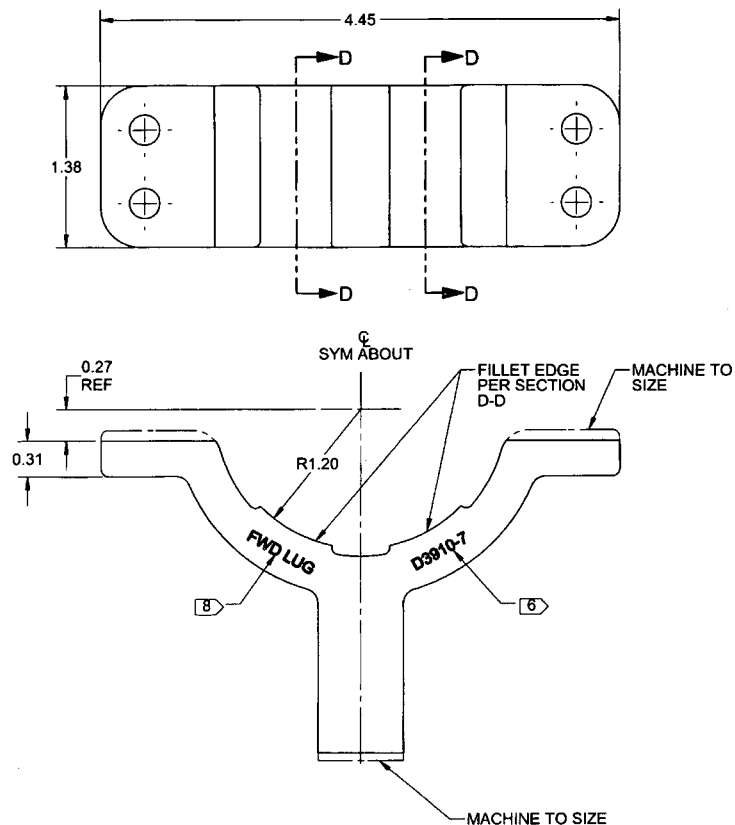
2014 JUN 05 *qp*

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MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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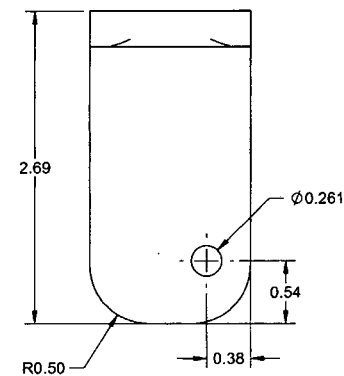
SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL







D3910-7 X-TUBE LUG



RELEASED

2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3910	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24538**

Purchase Order Date 6/10/2014

PO Print Date 6/10/2014

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3910-7P AS PER DWG D3310-7 REV. E B120673	Crosstube Lug	6/23/2014 Yes 6/23/2014	FN	60.00 Each	\$31.55	\$1,893.00
						Line Total:	\$1,893.00
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A007 first article inspection A016 personnel qualification A026 certification of materila conformance A040 notification of escape clauses A042 dart notification by supplier A043 retention of quality document	PROCUREMENT QUALITY CLAUSES	6/23/2014 No 6/23/2014		1.00	\$0.00	\$0.00

Note:

6/10/2014



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 20037
Date: Jun 19, 2014
Page: 1

Sold to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 24538	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Jun 19, 2014

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-7 Crosstube Lug, as per drawing D3910-7 REV.E	Each	60	60	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D 3910-7P	Crosstube Lug	24538

MATERIAL: supplied by DART B115529

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, June 19 2014